

Work Order ID 86062

June-20-12 12:51:45 PM

86062

Page 1

Item ID: D3675-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: SLIDING DOOR BRACKET

Start Date: 20/06/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/20 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3675 | RevD | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | FLOW WATER JET | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3675 | | | | | | | | |
| <u>3.54 - 0.45</u> | Dwg Rev: <u>0</u> | | | | | | | | |
| | Prog Rev: <u>0</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

24 0 Jun 12-6-23

24 0 Jun 12-6-23

24 12 06 24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 86062

June-20-12 12:51:45 PM

86062

Page 2

Item ID: D3675-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: SLIDING DOOR BRACKET

Start Date: 20/06/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 130 *130* Brake NC | NC BRAKE | 0.00 | | | | <u>24</u> | | | <i>8/12/06/25</i> |
| Brake NC | Memo Form as per Dwg D3675 use DT9723 | 0.00 | | | | | | | |
| 140 *140* QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | <u>24</u> | | | <i>W/120625</i> |
| Quality Control | Memo | 0.00 | | | | | | | |
| 150 *150* Powdercoat | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 | 0.00 | | | | <u>24</u> | <i>d</i> | | <i>AK 120627</i> |
| Powder Coating | Memo START TIME: <u>9:00</u> OVEN TEMPERATURE: <u>325°</u> FINISH TIME: <u>9:30</u> | 0.00 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

June-20-12 12:51:45 PM

86062

Page 3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: SLIDING DOOR BRACKET

Stop *NS2*

Start Date: 20/06/2012 **Start Qty:** 24.00

24

Cust Item ID:

Required Date: 04/07/2012 **Req'd Qty:** 24.00

24

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160 QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170 Identify as per dwg & Stock Location: 236A 0.00

0.00

170

Packaging

Memo

0.00

Packaging

| | | |
|-----|---|------|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 |
|-----|---|------|

0.00

180

QC

Memo

0.00

Quality Control

12/6/28 *[Signature]*

ME
12-06-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-20-12 12:51:49 PM

Page 1
T

Work Order ID: 86062

86062

Parent Item: D3675-1

D3675-1

Parent Item Name: SLIDING DOOR BRACKET

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A new issue 08-04-21 DD verified by:EC IPP Rev:B
11.01.11 as per dwg rev.C DD verified by:EC IPP Rev C 11.03.31
ECN 11-531 EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S20GA | | Purchased | No | | | 100 | sf | 375.0693 | 0.121 | 3.056842 | | | |

M304S20GA

**

Jm 12-6-23

304/316 .040 Sheet

Location

Loc Qty

Loc Code

001

52.4914105

121192

52.4914105

MAT020

322.577922

117933

27.3442

118400

5.3723

118964

23.2

119346

24.8

121380

49.761422

121901

192.1

121901

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

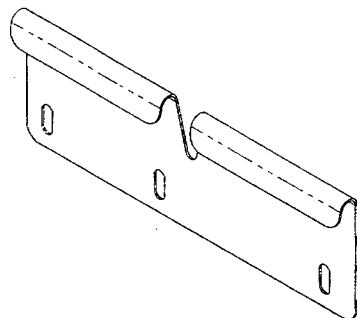
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

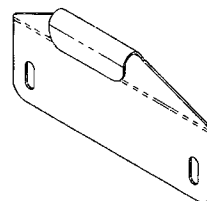
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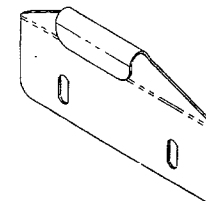
NOTE: Date & initial all entries



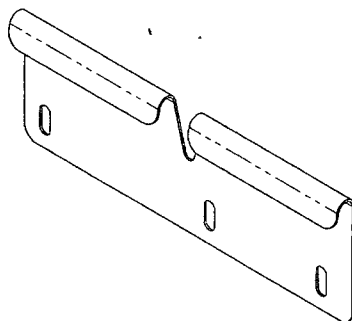
D3675-5 SLIDING DOOR BRACKET



D3675-1 SLIDING DOOR BRACKET



**D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)**



D3675-6 SLIDING DOOR BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86062 MJS
12/06/20

RELEASED
2011-03-30

| | | | | |
|------------|----------|--|--------------|------|
| DESIGN | AJS | DESCRIPTION | BY | DATE |
| DRAWN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | AJS | DRAWING NO. D3675 | REV. D | |
| MFG. APPR. | AJS | | SHEET 1 OF 6 | |
| APPROVED | AJS | TITLE SLIDING DOOR BRACKET | SCALE | |
| DE APPR. | AJS | (COMPOSITE DOOR) | NTS | |
| DATE | 11.03.21 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | |

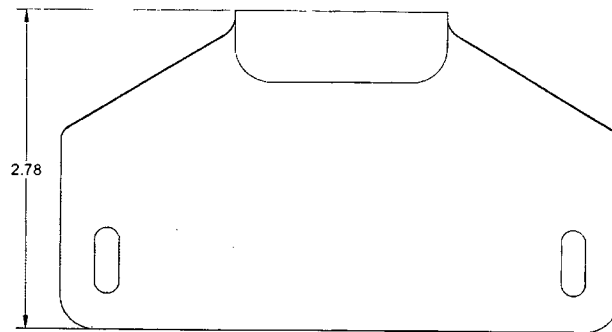
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

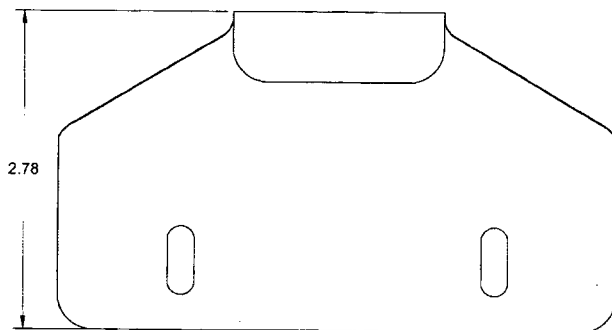
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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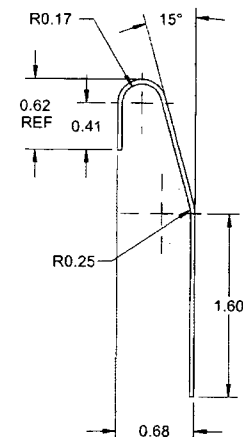
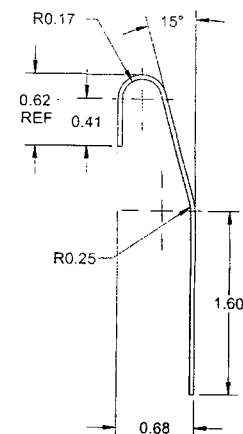
NOTE: Date & initial all entries



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



260062

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

| | | | |
|------------|----------|-----------------------------|----------------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | AS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. D |
| MFG. APPR. | AS | D3675 | SHEET 2 OF 6 |
| APPROVED | AS | TITLE | SLIDING DOOR BRACKET |
| DE APPR. | AS | (COMPOSITE DOOR) | SCALE |
| DATE | 11.03.21 | | NTS |

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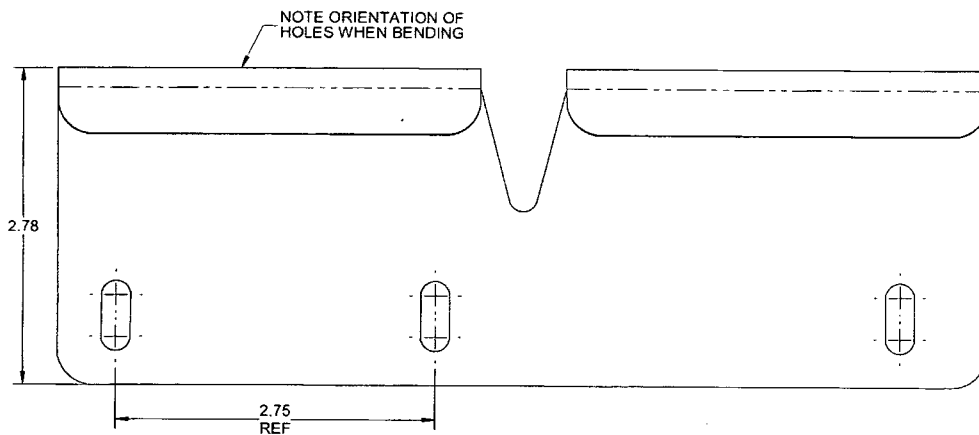
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

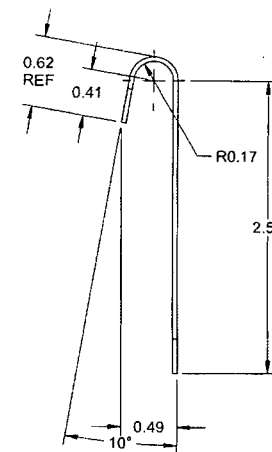
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3675-5 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.

| | | | |
|------------|----------|-----------------------------|----------------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | B | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. D |
| MFG. APPR. | N | D3675 | SHEET 3 OF 6 |
| APPROVED | 140 | TITLE | SLIDING DOOR BRACKET |
| DE APPR. | 140 | (COMPOSITE DOOR) | SCALE |
| DATE | 11.03.21 | | NTS |

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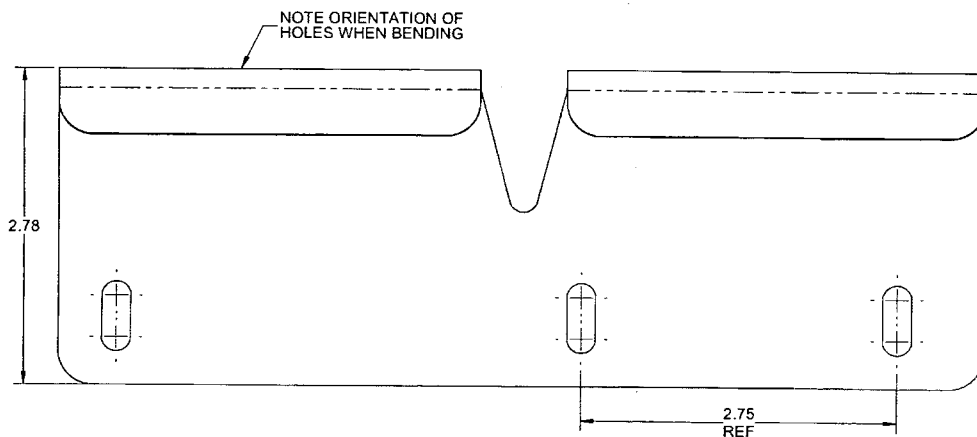
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

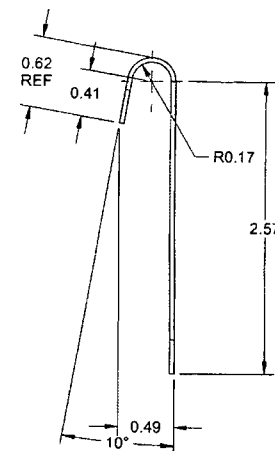
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | | | | |
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NOTE: Date & initial all entries



D3675-6 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



RELEASED
2011-03-31
MP

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

| | | | |
|------------|------------|--|----------------------|
| DESIGN | <i>AJS</i> | DART AEROSPACE LTD | |
| DRAWN | <i>AJS</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>AJS</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>DS</i> | D3675 | SHEET 4 OF 6 |
| APPROVED | <i>MP</i> | TITLE | SLIDING DOOR BRACKET |
| DE APPR. | <i>MP</i> | (COMPOSITE DOOR) | SCALE NTS |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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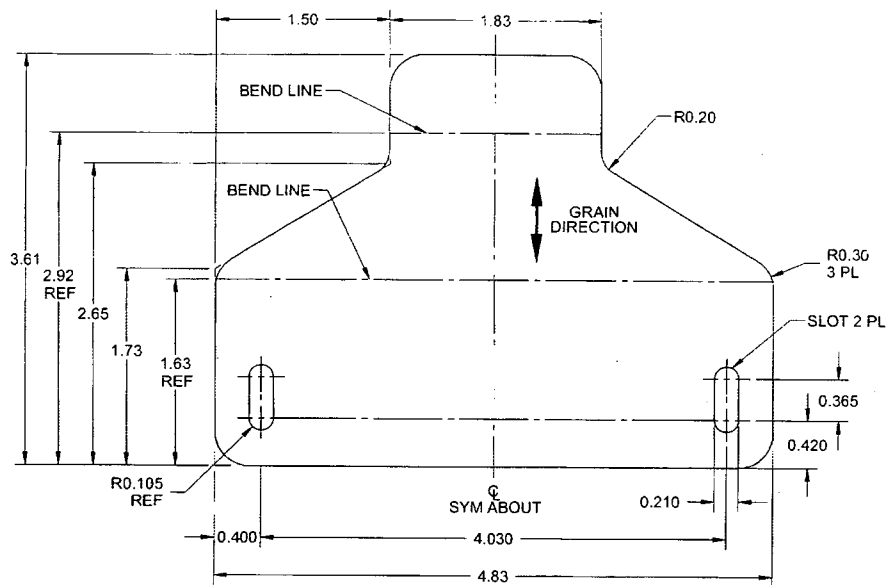
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

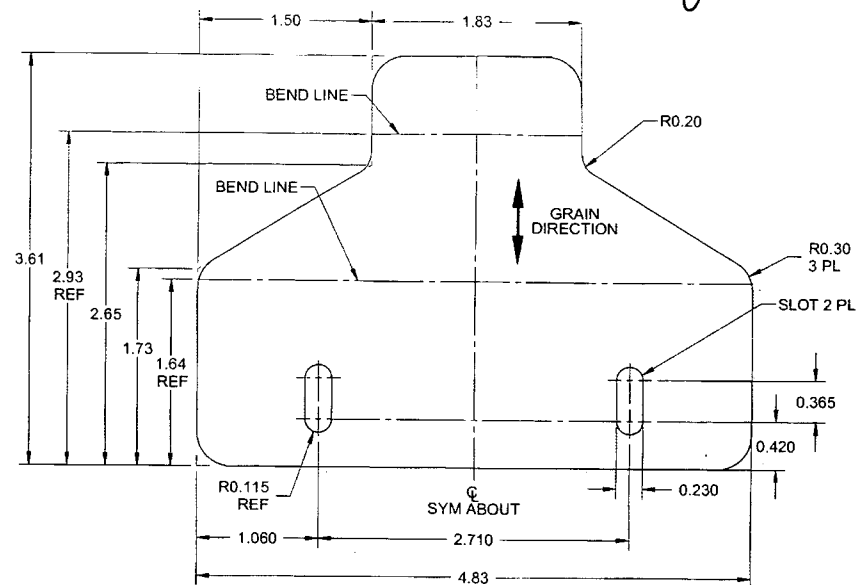
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

86062



D3675-1F FLAT PATTERN



D3675-3F FLAT PATTERN

RELEASED
2011-03-31
MD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

| | | | |
|--|----------|-----------------------------------|--------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | B | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AJS | DRAWING NO. D3675 | REV. D |
| MFG. APPR. | N | SHEET 5 OF 6 | |
| APPROVED | MD | TITLE SLIDING DOOR BRACKET | |
| DE APPR. | MD | (COMPOSITE DOOR) | |
| DATE | 11.03.21 | SCALE NTS | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

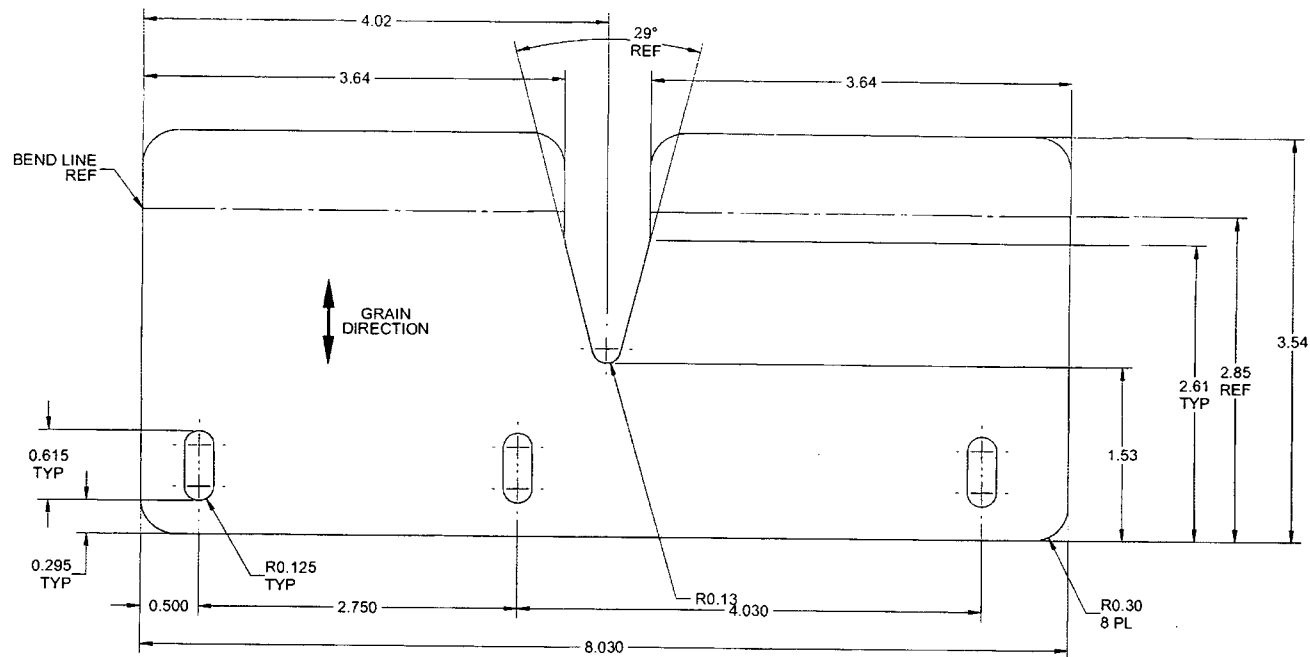
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

86062



D3675-5F FLAT PATTERN

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

| | | | |
|--|----------|--|--------------|
| DESIGN | ASIS | DART AEROSPACE LTD | |
| DRAWN | ASIS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASIS | DRAWING NO. | REV. D |
| MFG. APPR. | ASIS | D3675 | SHEET 6 OF 6 |
| APPROVED | ASIS | TITLE | SCALE |
| DE APPR. | ASIS | SLIDING DOOR BRACKET (COMPOSITE DOOR) | NTS |
| DATE | 11.03.21 | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries